2- deburr and break all sharp edges

NCR:	Yes	/	No

DQA: Date:

NCR: Y	es / No				WORK ORDER NON-	CONFOR	WANCE / UP	DATE	QA Closed:	Dat	e:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N				···	Rework Scrap		Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o		-		Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root			·		iption of work order update	Initial	i	tion	Sign &	t.	
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc.	cription	Date	Verification	QC Inspector
oc/Data							<u> </u>				
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perator	_	1									
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etup											
Other		1									
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upplier	┥ .										
raining Inapproved	$\dashv$										
mapproved 1	1		<u> </u>	l		FAULT CATI	GORY		<u> </u>		
Landin	g Gear				General						
[	Bending	Į			Bend	Grain			Ovalized	Γ	Pressure/Forced
( 4		Not Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks	* .			Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
ľ	Crushed	/Crimped		·	Burrs	Instruc	tions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
Ī	Cuffs	i i	r		Contamination	Maint	enance	. [	Part Moved	· .	
Ì	Heat Tr	eat			Countersink	Mislab	eled		Positioned V	Vrong	
ļ	Inspect	ion Strip in	Tube		Cut Too Short	Misrea	ıd ·		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	Offset		_			
Ţ	Torque	Waves in I	Extrusio	n [	Drawing	Out of	Calibration				
	Turning	Sequence	<b>!</b>		Finish	Out of	Sequence				
Ī	  Wave/T	wist in Tu	be		Folio	Outsid	e Dimensions				

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Work Order ID 100542	W	nrk	Order	ID	100542
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Hand Finishing

## \*100510\*

Page 2

April-22-13 1:	44:12 PM				10.54							,
Item ID: Revision ID: Item Name: Start Date:	646.3312 Center Plate 4/22/13	Start Qty: 10.00	*10*	Accept		I9000	401(	<b>``</b>	Setu	p Start Stop	17.	S1* S2*
Required Date	: 4/22/13	<b>Req'd Qty:</b> 10.00	*10*		(	Customer:		•				
Reference: Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:		· · · · · · · · · · · · · · · · · · ·	Run	Start Stop		R1* R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	s	Tool ID T	ool# Pla Co		-		Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00	۵.۵	13/05/0	9		0	<b>ø</b>		08 08 
130 *130* QC Quality Control		QC8- Inspect parts - seco	and check	0.00	ork,	13/6\$16	2		10	JE		
131 *131* HandFinish	pr	Memo		0.00	и '				10 -	AG)	3.5-2	77-

CLEAN AND REMOVE ALL PART MARKING

NCR:	Yes	/	No

NCR: Y	es	/ No					<b>WORK ORDER NON-C</b>	100	<b>NFORM</b>	MANCE / UP	DATE					
		·								·			QA Closed:	Da	te:	
Work Orde	r: _						DISPOSITION	1				DE	PARTMENT			
Part N	o						Rework Scrap		Г	Skid-tube Machining	Crosstube Small Fab Finishing		4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	o						Use-as-is Work Order Update			noforming Large Fab	Composite		Recystor	Supplier		Other
Root	ı				Desc	rip	tion of work order update	ı	nitial	Act	ion		Sign &			· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	n	QC Inspector
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Landin	g G	ear					General		_				_			
[	7	Bending			Γ		Bend		Grain				Ovalized			Pressure/Forced
. [		Centre No	t Concer	ntric to (	o/s [	$\sqcap$	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	$\neg$	Cracks					Broken/Damaged	П	Inspecti	on Incomplete			Part Incorre	ct		Weld
Ī		Crushed/C	Crimped		Γ		Burrs		Instruct	ions Incomplete/L	Jnclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	$\neg$	Cuffs			Γ	T	Contamination	Г	Mainte	nance			Part Moved	•		
<u> </u>	٦	Heat Treat	t		F	ヿ	Countersink		Mislabe	led			Positioned V	Vrong		
ļ-	٦,	nspection	Strip in	Tube	r	ヿ	Cut Too Short		Misread	l			Power Loss/	Surge		Other
F	_	Ripples in				$\exists$	Drill Holes		Offset		•		4			
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Ì	-	Turning Se					Finish		Out of S	equence			-			
		Wave/Twi	-	e	<u> </u>		Folio	$\vdash$	1	Dimensions						

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord April-22-13 1:4		00542		*100	542*							Page 3
Item ID: Revision ID: Item Name:	646.3312 Center Plate			Accept	*N900	040	100	)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	4/22/13 :: 4/22/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:						
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NI	R1* R2*
Sequence ID/ Work Center I  140  *140* Outsource4  Outsource process	ID	Operation Description Outsource process-Anodi:  Memo Issue P/O:		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qty	, I	Reject Number	Insp. Stamp
150 *150* Packaging Packaging		Receive & Inspect for Da	mage & Mat'l Certs	0.00				10	-X	<del></del>	7 3	80 3-6-6
155 *155* QC		QC5- Inspect part comple	teness to step on W/O	W 00.00								· .

Memo

Quality Control

NICD:	Voc	,	Nia
NCR:	Yes	/	No

NCR: Y	es / No				<b>WORK ORDER NON-</b>	CON	<b>FORN</b>	MANCE / UPI	DATE			•
	-							-		QA Closed:	Date	•
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	0		,		Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	<b>→</b>	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	In	itial	Act	ion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector
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quip/Tooling												
perator [												
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Other												
rocess					·							
Supplier												
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Inapproved											<u> </u>	
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Landir	ng Gear				General					_		_
ĺ	Bending	5			Bend	$\Box$	Grain		[_	Ovalized		Pressure/Forced
* [	Centre	Not Conce	ntric to	o/s [	BOM/Route	$\square$	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorred	t [	Weld
	Crushed	I/Crimped			Burrs	$\Box$	nstructi	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
İ	Cuffs				Contamination		Mainte	nance		Part Moved		
1	Heat Tr	eat			Countersink		Mislabe	led		Positioned V	/rong	
	<del> </del>	on Strip in	Tube		Cut Too Short	П	Misread	I		Power Loss/	Surge	Other
	Ripples	•			Drill Holes	П	Offset		_	_	<u> </u>	
•		Waves in I	Extrusio	,	Drawing	$\square$	Out of C	Calibration				
	<b>—</b>	Sequence			Finish	$\square$	Out of S	equence				
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DQA:

Date:

Work Ordo April-22-13 1:4		0542		*100!	542*				Page 4
Item ID: Revision ID:	646.3312 Center Plate			Accept	*N900040	1100*	Setup	Start Stop	*NS1* *NS2*
Item Name: Start Date: Required Date: Reference:	4/22/13	<b>Start Qty:</b> 10.00 <b>Req'd Qty:</b> 10.00	*10* *10*		Cust Item ID: Customer:		·		INO
Approvals:		in:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* SprayPaint SprayPaint	<b>D</b>		5 4.2 ER DWG, SEE NOTE #2 TCH: しょら 45 る		Tool ID Tool	# Plan Ac Code Qt	cept Rej y Qty	y r	Reject Insp. Number Stamp
*170* QC Quality Control		QCT Inspect Spray Pair  Memo	it	0.00 3 6	1	10	<u> </u>		· · · · · · · · · · · · · · · · · · ·

180

\*180\*
Packaging

Memo

Packaging

\*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV\*\*\*

											DQA:	Da	te:	•
NCR: Y	es / No				WORK ORDER NON-C	ONFO	ORN	MANCE / UPD	ATE		_			•
<del> </del>		- <u>-</u> -								C	QA Closed:	Da	te:	
Work Orde	ı <del>r.</del>				DISPOSITION				AGAINST D	EP	ARTMENT/	PROCESS		
Work Orde	···		_		Rework			Skid-tube	Crosstube		•	Water Jet	Γ	Engineering
Part N	lo.				Scrap		ſ	Machining	Small Fab	]	Prod	l. Eng. Coor.		Quality
	·			<del></del>	Use-as-is	Tł	hern	noforming	Finishing		Rec/Stor	e/Packaging	-	Other
NCR N	lo				Work Order Update			Large Fab	Composite	╛		Supplier	_	
		<del></del>	ī	·			-1	A -4:		Т	C: 0			<u> </u>
Root				l .	ption of work order update	Initi		Acti		ı	Sign &	\		061
Cause	Date	Step	Qty	- (	or Non-conformance	Chief	Eng	Descri	ption	+	Date	Verificatio	<u>n</u>	QC Inspector
Doc/Data	_													
Equip/Tooling											Ī			
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	Centre	Not Conce	ntric to	o/s	BOM/Route	Har	rdwa	ire		_]c	Over/Under t	olerance		Temperature/Cure
	Cracks				Broken/Damaged	Ins	pecti	ion Incomplete		P	Part Incorrec	t		Weld

Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

Maintenance

Mislabeled

Instructions Incomplete/Unclear

Wrong Stock Pulled

Part Lost/Missing

Positioned Wrong

Part Moved

Cuffs

Heat Treat

Crushed/Crimped

Burrs

Contamination Countersink

Work Ord		0542	٠	*100542*						
Item ID: Revision ID: Item Name:	646.3312 Center Plate			Accept	*N900040100*	Setup	Start Stop	*NS1* *NS2*		
Start Date: Required Dat Reference:	4/22/13 re: 4/22/13	Start Qty: 10.00 Req'd Qty: 10.00	*10 *10		Cust Item ID: Customer:					
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:	Run	Start Stop	*NR1* *NR2*		

Set Up/

0.00

0.00

**Run Hours** 

Sequence ID/

\*190\*

Quality Control

190

Work Center ID

Operation

**Description** 

QC21- Final Inspection - Work Order Release

Memo

Tool ID

Tool # Plan

Code

Number Stamp

Insp.

Reject

Qty

Accept

Qty

Reject

MF 13-6-10

										DQA:	Date:	•
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
					1					QA Closed:	Date:	
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	<b>∤</b>	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	ło				Work Order Update	J		Large Fab	Composite	J	Supplier	
Root		1		Descri	iption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
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Supplier												
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	Bending	[		, [	Bend		Grain		L	Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion incomplete		Part Incorre	ct	Weld
	Crushed	I/Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tr	eat			Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspecti	on Strip ir	1 Tube		Cut Too Short	Γ	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

April-22-13 1:44:12 PM

Work Order ID:

100542

Parent Item:

646.3312

Parent Item Name:

Center Plate

**Start Date:** 4/22/13

Required Date: 4/22/13

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP REV:A NEW ISSUE 12/11/16 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B5.000X0.375		Purchased	No			100	f	59.9160	0.68	7.1578947			
7075-T6 BAR 5.000" X 0.	375"										ж. <i>у</i> аз		
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT049		59.916							
				123	218	44.362					1		
				<b>→</b> 123-	418	15.554			<u>7.16</u>	MH	bu13	/os/o <sup>-</sup>	7

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NCR: Y	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	PD	ATE			<del></del>		
									<u></u>			QA Close	ed:	Date	:	
Work Orde	oř.					DISPOSITION					AGAINST DE	PARTMEI	NT/P	ROCESS		
Part N	No. <sub>.</sub>				,	Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab		Crosstube Small Fab Finishing Composite	-1		Water Jet Eng. Coor. /Packaging Supplier	En	gineering Quality Other
Root					Descri	ption of work order update		Initial		ctic	on	Sign &				
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	crip	ption	Date	$\perp$	Verification		QC Inspector
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Setup													-			
Other													Ì			
Process							1								1	
Supplier							1						- 1		1	
Training							1						1			
Unapproved															<u> </u>	
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Landi	ng (	Gear				General										
		Bending				Bend		Grain				Ovalized			Press	sure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re			Over/Und	ler to	lerance	Tem	perature/Cure
	$\Box$	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incor			Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread Offset DQA:

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

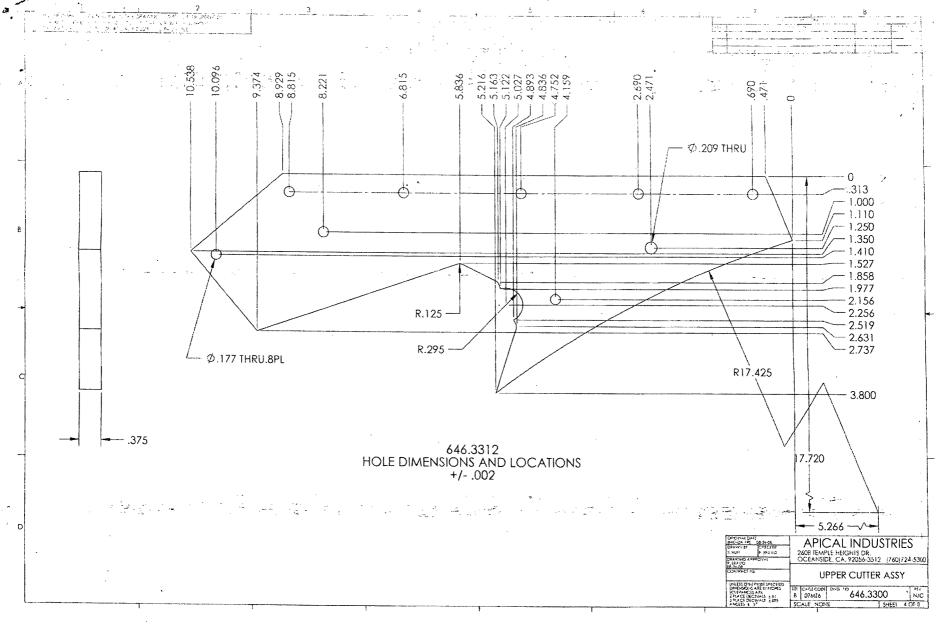
Cut Too Short

Drill Holes

Drawing

Finish

Folio



SHOP COLY

REMODELLA

ENGINEERING

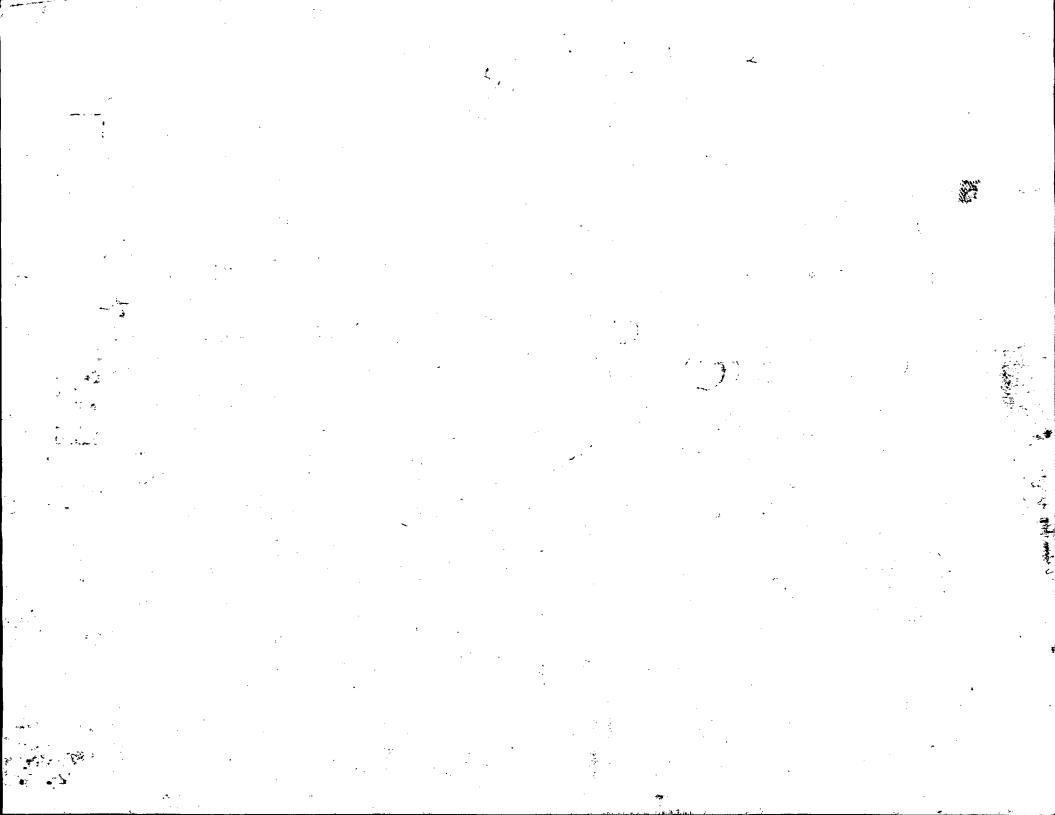
UNCORTA HELD CORY

SEPECTOR ENDINE

TOWN, TO THE

100542 MC5

13-04-24



DART AEROSPACE LTD	Work Order: 100542
Description: CENTER PLATE	Part Number: (46.3312
Inspection Dwg: 646.3300 Rev: NC	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/005	0.371	~		Mic	GA-03
\$6.177	4/002	\$6.178	~		Vern	6A-01
\$6.209	+1007	\$0.210	~		11	U
10.338	+/005	10.535	~		H-6	. 31006
10.096	+1002	10.095	~		1)	1)
8.815	+1002	8.814	~		- 11	()
6.815	+1002	6.814	~		/!	n
5.216	+  005	5.213	<u></u>		- 11	4
4.752	+/002	4,751	~			Ч
4.159	+1002	4.158	レ		4	lj.
2.690	+1002	2.689	~		П	4
2.471	+1002	2.470	レ		11	Д
0-690	+1002	0.689	<b>→</b>		И	11
	·					
0.313	+1002	0.314	>		13	٨
1.000	+1002	1.001	>		11	(1)
1-250	+1002	1.252	>		11	11
1.410	+1002	1.411	)		11	0
2.156	+1002	2.158	<b>\</b>		Ŋ	11
2.737	+1005	2.736	>		41	1)
3.800	+/005	3.798	/		ιl	1)
·						
			÷			

Measured by:	5.9	Audited by:	and	Preliminary Approval:	
Date:	13 05 098-89	Date:	13/05/12	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

### Pack List

Number: 62433

Date: 06-Jun-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

rms		Ship Via		
Quantity	Description			
1	Part: ASST		Rev:	
lot	10 PCS 646.3310 10 PCS 646.3312 10 PCS 646.3313 10 PCS 646.3610			
: •	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2	. در ژ <del>ه</del> در چې		
ě	PRIME MIL-P-23377J TYPE I CLAS	SS N		
	Job: 20130348	PO: 19997	Line:	
1	Part: ASST		Rev:	•
1 lot	20 PCS 646.3712 20 PCS 646.3716 19 PCS 646.3711		Rev:	
	20 PCS 646.3712 20 PCS 646.3716		Rev:	
	20 PCS 646.3712 20 PCS 646.3716 19 PCS 646.3711 HARD ANODIZE BLACK	SS N	Rev:	
	20 PCS 646.3712 20 PCS 646.3716 19 PCS 646.3711  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLAS 12 PCS D4703-043 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2		80	B-6-le-
	20 PCS 646.3712 20 PCS 646.3716 19 PCS 646.3711 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLAS 12 PCS D4703-043 BLACK ANODIZE	SS N PO: 20070	Rev:	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

#### Pack List

Number: 62433

Date: 06-Jun-13

Τo

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7. Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

n: 613-632-5	200 Fax: 613-632-1185		Ph: 613-632-5200	Fax: 613-632-1185
rms		Ship Via		
Quantity	Description			
	A.T.G. Industries certifies that all items i with all requirements, specifications and ISO 9001 : 2008 REG ATG SALES-2010 TEDATE :	drawings reference	e in conformance ed in the purchase order.	

#### \*\*\*OUTSTANDING PO REPR

#### Purchase Order ID PO19997

Purchase Order Date 5/28/2013 PO Print Date 6/6/2013

Page Number 2 of 4

der From :

VC-ATG001

A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE ROAD ROCKLAND, ON K4K 1T2 **CANADA** 

**Contact Name** 

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

**FOB** 

Destination-Collect

Line Nbr Reference

**Revision ID** Vendor Part Number Description/

Mfg ID

Req Date/ Taxable

Req Qty

**Unit Price** 

Line Total:

**Extended Price** 

\$0.00

Special Inst:

FINISH BLACK ANODIZE PER IAW

MIL-A-8625 TYPE III,

CLASS 2, COLOR BLACK

FINISH: PRIME AS PER IAW MIL-P-

23377J TYPE I CLASS N

100542

646.3312 CENTER PLATE

6/7/2013 Yes

10.00

\$12.4625

\$124.63

\$124.63

Special lest:

FINISH BLACK ANODIZE PER IAW

MIL-A-8625 TYPE III,

CLASS 2, COLOR BLACK

FINISH: PRIME AS PER IAW MIL-P-

23377J TYPE I CLASS N

100368

646.3313 UPPER GUIDE

6/7/2013

10.00

\$12.4625

\$124.63

Special Inst:

FINISH BLACK ANODIZE PER IAW

MIL-A-8625 TYPE III,

Yes

Line Total:

Line Total:

\$124.63